

Work Order ID 119743

May-21-14 9:24:35 AM

119743

Page 2

Item ID: D2270-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Raidus Block
Start Date: 5/21/14 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 5/21/14 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 13 9-89
120		0.00				2	Ø		14-6-2	
120										
Mill Conv	Memo	0.00								
Conventional Milling Machine	Machine CMFas per dwg D2270									
	Deburr									DAS 13 8-6
130	QC2- Inspect parts off machine FAI/FAIB	0.00				2	Ø		14-6-2	
130										
QC	Memo	0.00								
Quality Control										
140	QC8- Inspect parts - second check	0.00				2				
140										
QC	Memo	0.00								
Quality Control										

Smp
14/6/3

Work Order ID 119743

May-21-14 9:24:35 AM

119743

Page 3

Item ID: D2270-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Raidus Block
 Start Date: 5/21/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/21/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

SHIPPED TO DAVID S. *[Signature]*

14/9/9 *[Signature]*

POSITIVE RECALL
 EFFECTIVE 4/25/14 AUTH 11
 RELEASED 8 DATE 4/28/14

to Re C.D. ah.

WF
 14-6-3

Picklist Print

May-21-14 9:24:39 AM

Page 1

Work Order ID: 119743

119743

Parent Item: D2270-1

D2270-1

Parent Item Name: Raidus Block

Start Date: 5/21/14

Required Date: 5/21/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.05.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S12GA

Purchased

No

sf

111.6300

1

M304S12GA

**

Jm14-05-30

304/316 0.100" Sheet

Location

Loc Qty

Loc Code

MAT019

111.63

113062

76.13

113077

19

m126309

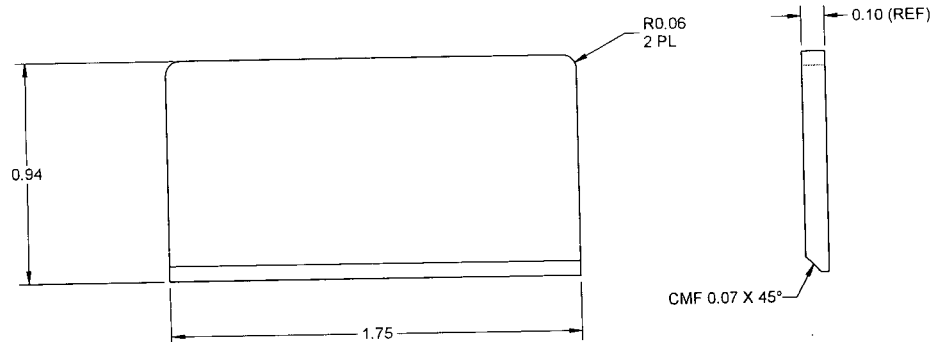
16.5

126309.

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D2270-1 RADIUS BLOCK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119743 MLC

1405-21

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 12 GAUGE 0.10 THICK, (REF DART SPEC M304S12GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

D	12 GAUGE WAS 11 GAUGE	DB	14.05.21
C	304 STAINLESS STEEL WAS 6061-T6 ALUMINIUM, 0.04 WAS 0.71, 0.10 WAS 0.125, CMF 0.07 X 45° WAS R0.125	DB	14.03.11
B	REDRAWN	RF	01.05.14
A	NEW ISSUE	RF	94.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. PD1
MFG. APPR.	DD	D2270	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	RADIUS BLOCK	NTS
DATE	14.05.21	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

UNAPPROVED

Shipping Order

11/07/2013

MÉTAUX SOLUTIONS INC
2625 BOUL JACQUES CARTIER EST
LONGUEUIL, QUEBEC
J4N 1L7 Tel: 450 641-3330

Order : 88960
Reference : 20491
Bid : 7547
Ship : PICK UP / PICK UP

Customer: 6323336

Ship To

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Same

Tel: 1 613 632-3336

Item No.	Description	Qty	Qty. Delivered	B/O Qty
AS03261	ALU SHE .032 6061-T6 (20G) 8 X 4' X 12' HT;36194/01	384	384	Ø
AS08061	ALU SHE .080 6061-T6 (12G) 8 X 4' X 12' HT;42000/01	384	384	Ø
AS1875	ALU SHE .125" X 48" X 144" 7075-T6 1 X 4' X 12' HT;610007A7	1	1	Ø
SS122B4	304 SHEET .104 (12G) 2 X 4' X 8' HT;C34AY1207950	64	64	Ø
	SHIP TST COLLECT JP			

gr 1507.16

Shipping : _____
Package No : _____
Merchandise Received: _____

Ref. : _____

Shipping Order

11/07/2013

MÉTAUX SOLUTIONS INC
2625 BOUL JACQUES CARTIER EST
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SS122B4	304 SHEET .104 (12G) 2 X 4' X 8' HT;C34AY1207950	64	64	Ø
	SHIP TST COLLECT JP			

Shipping : _____
Package No : _____
Merchandise Received: _____

Ref. : _____

AMAG

ROLLING

Abnahmeprüfzeugnis 3.1 (EN 10204)

Inspection certificate - mill certificate

Nr.: 85246330

Rev.: 0

Seite / page:

1 von / of 2

Datum / date:

2013 04 19

Zertifiziert nach / certified to ISO 9001, ISO/TS 16949, EN/AS 9100, ISO 14001, NADCAP

Auftraggeber / customer: 18	Bestell Nr. / order no.:	C66386
	Datum / date:	2013 01 15
	Auftragsbest. Nr. / order confirm no.:	851503
	Datum / date:	2013 01 16
Warenempfänger / consignee:	Lieferschein Nr. / delivery note:	85246330
	Datum / date:	2013 04 30

Form / form: Sheet

Werkstoff / material: 6061

Zustand / temper: T6

Dim. / dim.: [inch]: 0,080x48,00x144,00

Technische Lieferbedingungen / techn. spec.:

AMS-QQ-A-250/11, 08.1997

ASTM B 209 - 10

AMS 4027N, 07.2006

ASME SB-209, 2011a

Sondervorschrift / special terms:

04	42000/01/00	01/0055174/3	6061	6515030012	3977,072 lbs	74
04	42000/01/00	01/0055174/3	6061	6515030013	3990,300 lbs	74

0770873

0770874

Guss Nr. / cast no.	material	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Others Each	Others Total
01/0055174/3	6061										
	spec. min.	0.40	-	0.15	-	0.80	0.04	-	-	-	-
	spec. max.	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	0.05	0.15
	actual	0.71	0.44	0.22	0.12	0.88	0.16	0.03	0.06	0.02	0.05

BNr/Los	Zustand	Richtung	Tests	UTS	YS	A2"			
Lot/No.	temper	direction		[ksi]	[ksi]	[%]			
			spec.min.	42,0	35,0	10			
			spec.max.	-	-	-			
42000/01	T6	LT	9	from	48,0	41,0	14		
42000/01	T6	LT		to	48,6	41,5	16		

Biegeversuch: OK. / Transverse bend test: OK.

Maßkontrolle: OK. / Dimensional Check: OK.

AMAG rolling GmbH, Postfach 32, A-5282 Ranshofen, Österreich - www.amag.at
 AMAG rolling GmbH, P.O. Box 32, A-5282 Ranshofen, Austria - www.amag.at



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO20491

Purchase Order Date 7/10/2013

PO Print Date 7/10/2013

Page Number 1 of 2

Order From :

VC-MET002

Ship To : DART AEROSPACE LTD

METAUX SOLUTIONS
2625 BOUL JACQUES-CARTIER EST
LONGUEUIL, QC J4N 1L7
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
6/30/13

Contact Name

Vendor Phone 800 558 8858

Ship To Contact

Ship To Phone

Ship Via: TST ground

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

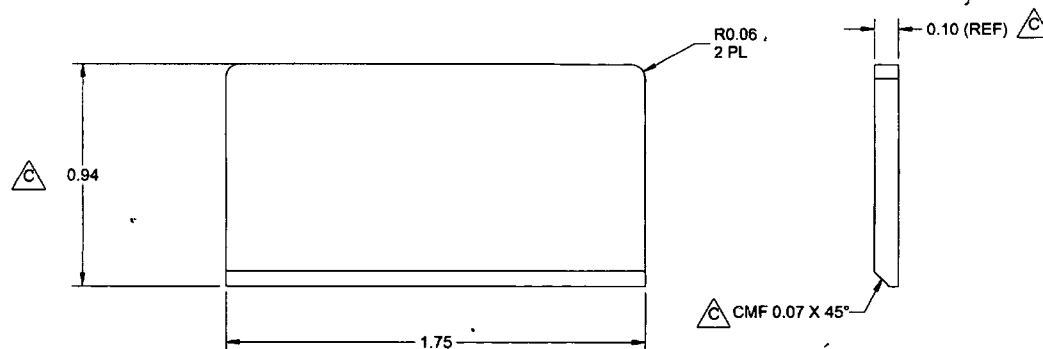
Destination-Collect

M 126 309

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	List Price	Disc %	Discounted Unit Price	Extended Price
1	M6061T6S.032	6061-T6 Sheet 0.032"	7/12/2013 Yes 7/12/2013		384.00 sf				\$806.40
	MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209								
								Line Total:	\$806.40
2	M6061T6S.080	6061-T6 .080 Sheet	7/12/2013 Yes 7/12/2013		384.00 sf				\$1,670.40
	SAME AS ABOVE								
								Line Total:	\$1,670.40
3	M304S12GA	304/316 0.100" Sheet	7/12/2013 Yes 7/12/2013		64.00 sf				\$758.40
	MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240/ASME SA240								

Note:

7/10/2013



D2270-1 RADIUS BLOCK

RELEASED
2014-08-27

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 11 GAUGE 0.10 THICK, (REF DART SPEC M304S11GA)
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	DD	D2270	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	RADIUS BLOCK	NTS
DATE	14.03.11	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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